Aero Design Ltd.

Work Order Control Sheet

Work Order#: 2015-74 **Date Opened:** 24-Jun-15 **Title:** Assembly

Aircraft OEM: Eurocopter **Aircraft Model:** AS350/355 **Product Type:** Body **Product Model:** XL Ski **Quantity:** 3

Work Order Contents

	Initial or N/A
Work Order/Build Sheets (Procedures Provided)	JC
Additional Work Sheets (Standard Practice)	N/A
Drawings (See List Below)	JC
Parts Distribution Sheet	JC
Sub Component Tags	JC
Completed Certification (Original)	JC N/A JC
Time Sheet (R&D)	N/A
Notes	N/A

Build Sheet Contents

	Initial or N/A
Tasks Initialled	JC
Dual Inspections Initialled	JC

Drawing List

Drawing #	Rev #	Description	Initial or N/A
94011	1	Basket Body	JC
94023	1	Att Hoop	JC
94030	1	Hoop	JC

Traveller

Initial or N/A

Component Completion

	As Instructed
Quantity Complete on This Work Order	3
Quantity Incomplete on This Work Order	0
Further Processing Required Before Release	N/A
Release to Stock as Components	See notes

Certification

	Initial or N/A
Form One Completed	N/A
Serviceable (Green) Tag Completed	N/A
In Process (Yellow) Tag Completed	N/A
Unserviceable (Red) Tag Completed	N/A
Parts Tracking Tag (White) Completed	JC
Parts Placed in Stores for Distribution	JC

Additional Documentation

	Initial or N/A
Documentation of a minor change	N/A
Non-Conformance Report Required	N/A
Service Difficulty Report Required	N/A

Billing

	Initial or N/A
Local (Aero Design)	JC
Research and Development	N/A
Third Party	N/A

Notes

Extra components produced for stock:
24 x 94030-01 Hoop
6 x 94023-01 Attachment Hoop

Work performed by:	Print: M. Rekve	Sign: for M. Rekve	SCA: AD06	Date:	13-Jul-15
ICC / Dual Inspection preformed by:	Print: Jason Rekve	Sign:	SCA: AD01	Date:	13-Jul-15
Work Order closed by:	Print: Jeff Clarke	Sign:	SCA: AD02	Date:	18-Jan-16

WO#2015-74 Date Opened: 24-Jun-15

940

BASKET BODY x3

CARGO BASKET BODY FABRICATION - COMMON

General

These instructions apply to all cargo basket body assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

Bell 206L/407 – Right side only
69811, Revision 3 – Standard Low Mounted Basket
94511, Revision 0 – Extra-Wide Low Mounted Basket
94611, Revision 0 – Extra-Wide Low Mounted Ski Basket
76611, Revision 0 – High Mounted Ski Basket
Options 70404, Revision 2 – Front end cutout – 698
70411, Revision 0 – Front end cutout – 945/946

Eurocopter AS350/AS355 – left or right
77611, Revision 1 – Short Basket
76411, Revision 3 – Medium Basket (left or right)
78411, Revision 2 – Long Basket
94011, Revision 0 – Extra Large (ski) Basket
Options 70406, Revision 2 – Front end cutout – 764/776/784/940

Robinson R44 – left or right
90611, Revision 0 – Standard Basket (left or right)

Bell 206B – right side only
80211, Revision 0 – Short Basket
80311, Revision 0 – Medium Basket
81111, Revision 0 – Long Basket
Options 70406, Revision 2 – Front end cutout – 802/803/811

Bell 429 – right or left
95911, Revision 0 – Standard Basket

Bell Medium – left or right
75111, Revision 0 – Standard Basket
95511, Revision 0 – Extra Large (ski) Basket
Options 70407, Revision 1 – Front end cutout – 751
704 , Revision – Front end cutout – 955

MD600
82811, Revision 0 – Standard Basket

Options – Applicable to all models
70403, Revision 5 – Auxiliary Latch

CARGO BASKET BODY FABRICATION - COMMON

Complete
(initial or SCA #)

Work Order: 2015-74

Date Open: 24-Jun-15

1. Rim Assembly – Basket Body — ADC
   a. Cut and fit ¾" x 0.035 material to fit rim jig.
      i. 1 or 2 lid prop bushing holes in short tube – refer to drawing
   b. Record material PO on attached material list.
   c. Remove writing on tubes with acetone and scotch bright.
   d. For extra large baskets – drill #30 (0.129) vent holes to vent stringer tubes into rims.
   e. *94611 (206L/407 XL ski) only* – drill for 4 threaded bushings before assembling rim.

2. Weld Rim Assembly. — AD-05
   a. Record welding rod PO on attached material list.
   b. *94611 (206L/407 XL ski) only* – weld 4 threaded bushings into inboard rim tube.

3. Inspection — ADC
   a. Rim for complete welds

4. Frame assembly – body — ADC
   a. General
      i. Vent holes shall be #30 (0.129), and located inside the structure wherever possible to allow venting of weld gasses through existing holes (i.e. lid prop bushing, hoops, etc.)
   b. Grind corner welds from step 2 on rim to allow hoops to sit flat.
   c. Pull required hoops from stock - standard, attachment, handle.
      i. If hoops are not in stock see detailed procedure sheet for specific hoop fabrication.
      ii. Ensure vent hole is located at centre of tube to vent spine tubes.
   d. Assemble hoops with attachment lug locating jig and hoop spacing jig.
      i. Ensure correct order and orientation of hoops. Refer to drawing.
         1. Attachment lugs are on inboard side.
         2. Handle bracket bushings are on outboard side, second hoop from both ends. May be on attachment hoops.
      ii. Run 3/8-24 tap into attachment lugs to ensure clear threads.
      iii. Bolt attachment lug locating jig to attachment hoops with 3/8-24 bolts.
      iv. Attach inboard and outboard hoop spacing jigs to all hoops using 1" C-clamps. Raise jigs approximately 2" off table to allow room to weld around hoops.
      v. Attach bottom (spine) jig to all hoops using 1" C-clamps along the centre line of the basket. Ensure jig is straight prior to tightening all clamps.
   e. Cut ½" x 0.035 material to fit spine jig.
   f. Cut ½" x 0.035 material for strut to fit from lower inboard attachment to upper outboard rim.
      i. Refer to applicable drawing for position, not required on some baskets.
   g. *Option*: Cut ½" x 0.035 material for front end cutout. Record material PO on attached material list.
   h. *90611 (R44) only*: Cut ½" x 0.035 material to fit front end structure. Record material PO on attached material list.
   i. Drill vent holes into attachment hoop and/or rim to vent strut(s) and front end cutout.

j. Record hoop WOs and material POs on attached material list.
k. Remove writing on tubes with acetone and scotch bright.
l. Insert rim assembly into jig and set frame assembly onto rim. Ensure correct orientation of lid prop bushings in rim to frame. Bushing hole must be closer to attachment side.
m. Align hoops to rim in accordance with drawing. General positions:
    i. Extra large baskets
        1. inboard side of hoops (attachment side) aligns to OUTSIDE of rim
        2. outboard side of hoops (handle side) aligns to INSIDE of rim
        3. forward and aft hoops align to INSIDE of rim
    ii. All other baskets
        1. inboard side of hoops (attachment side) aligns to INSIDE of rim
        2. outboard side of hoops (handle side) aligns to INSIDE of rim
        3. forward and aft hoops align to INSIDE of rim, except R44

5. TIG weld frame to rim assembly. AD-05
    a. Ensure lug locating jig and hoop locating jigs are in place. Jigs must remain in place for as long as practical during welding.
    b. Strut tubes and front end cutout (see step 4.f. and g.) must be welded in place after the hoops are welded to the rim. Jig(s) must be in place prior to welding strut tubes.
    c. Robinson R44 (90611) requires fitting and welding of forward end after remainder of basket frame is welded. Use jig to support front hoop.
    d. Record welding rod PO on attached material list.

6. Inspection AD06
    a. Frame assembly for complete welds.

7. Mesh assembly. AD06
    a. Pull sheet of expanded mesh from stock. Record material PO on attached material list.
    b. Cut mesh to size for body.
    c. Remove surface rust with scotch-brite.
    d. Bend body mesh – use table with bend markings on top. Lock wheels on table.
        i. For extra wide baskets only –
            1. Set ¾" angle along edge of table under mesh sheet. Set 1.5" square tube on top of mesh aligned with angle on edge of table. Clamp in place with 6" C-clamps.
            2. Bend upper edge of sheet just past a cell intersection to make a flange 2.5" - 3.25" wide. Closer to 2.5" is preferred, full cell intersection on flange side at bend is required.
            3. Bend down by hand as far as possible, then use a hammer to flatten the bend tight against the angle on the edge of the table.
        ii. Using markings on table, align sheet to indicated edge.
        iii. Using markings on table, align 3" tube to required position and clamp tube in place.
        iv. Bend mesh by hand tightly over tube along length of tube.
        v. Keeping mesh in place, un-clamp 3" tube, move to other position and clamp tube in place.
        vi. Bend mesh by hand tightly over tube along length of tube.
    e. Install attachment lug jig onto basket frame.

f. Ensure end struts are welded in basket frame if required by the drawing.
g. Insert mesh into basket.
    i. General
        1. Some cells may interfere with correct positioning, especially at the upper corners and around struts. Bend cell(s) in as required, do not cut cells off.
        2. Ideally welds will be located on mesh intersections. Shift mesh if possible to minimize welds located off mesh intersections.
        3. Ensure mesh reaches all edges of basket BEFORE trimming. Regardless of progress in clamping, remove clamps and shift mesh if required.
        4. Ensure cleco clamps are placed from the inside of the basket to allow removal during welding. Cleco clamps may be used from the outside during fitting, but must be removed prior to welding.
    ii. Extra large baskets only – seat corner of mesh with flange into inboard upper corner of frame. Use C-clamps on edge of flange as required to maintain tight fit.
    iii. Starting at inboard top edge of basket, clamp mesh to hoop near top rim using cleco clamps onto hoops. For regular size baskets, edge of mesh should sit approximately half way up rim tube.
    iv. Working down the inboard side, clamp mesh to hoops with cleco clamps. Clamp down into radius of hoop and continue clamping as required to maintain tight fit in corner of hoop. After the corners are tight, two clamps just onto the radius on both ends should be sufficient to hold the corner tight, remove all extra clamps.
    v. Clamp mesh to spine in at least 1 place per section.
    vi. Working up the outboard side, clamp the mesh into the radius of hoop and continue clamping as required to maintain tight fit in corner of hoop. After the corners are tight, 2 clamps just onto the radius on both ends should be sufficient to hold the corner tight, remove all extra clamps.
    vii. Trim upper outboard edge of mesh if required, edge of mesh must be low enough on rim tube to prevent the weld from protruding above the edge of the rim. Some sheets are tapered and may require ½ to 1 cell to be removed over some or all of the length of the basket. De-burr cut edges with a sanding disc on a die-grinder. Straighten cut cells with duck-bill pliers. Clamp mesh near upper edge to hoops with cleco clamps after trimming.
    viii. Trim ends to land on hoops, at mesh intersections if possible.
h. Cut mesh to fit ends. Record material PO on attached material list.
    i. Remove surface rust with scotch-brite.
    ii. Ensure mesh is cut at intersections where possible.
    iii. Bend top edge of mesh 1/8"-3/16" down at 45 degrees
    iv. Cut for front end cutout if required.
i. 90611 (R44) only: Cut mesh to fit upper forward end. Record material PO on attached material list.
    i. Remove surface rust with scotch-brite.
    ii. Ensure mesh is cut at intersections where possible.
    iii. Bend top edge of mesh 1/4" down at 60 degrees.
    iv. Fit mesh to front end of basket.

Complete
(initial or SCA #)

8. Weld mesh to frame assembly per drawing. AD-05
    a. Ensure lug locating jig is in place prior to welding.
    b. General welding requirements for all baskets, MIG welding:
        i. Every intersection at top edges.
        ii. Every intersection at ends.
        iii. First 5 intersections down on hoops, then every second intersection.
        iv. Every intersection along spine.
        v. Extra large baskets – every intersection along corner.
        vi. Every intersection around ends
        vii. Every intersection along struts (if applicable)
    c. Bend and trim cells bent in to fit mesh as required and weld in position.
    d. Grind high spots off body mesh welds on ends before welding end mesh.
    e. *90611 (R44) only* – weld lid prop bushing (step 9) into rim BEFORE welding upper mesh on forward end of basket assembly.
    f. Record welding rod PO on attached material list.

9. Weld basket components AD-05
    a. TIG weld lid prop bushing(s), one or two per drawing.
        i. Record welding rod PO on attached material list.
        ii. Record lip prop bushing WO on attached material list.
    b. TIG weld caps to close top of 1" hoops as applicable.
    c. 94611 (Bell206L/407 XL ski) only: cut rim over cross tube gap.
        i. Cut inboard rim on aft end. Grind flush with hoops.
        ii. TIG weld caps on open tubes.
        iii. Record cap material PO on attached material list.
    d. 95911 (Bell 429) only: placard bracket to forward upper corner of basket.
        i. Record welding rod PO on attached material list.
        ii. Record placard bracket WO on attached material list.

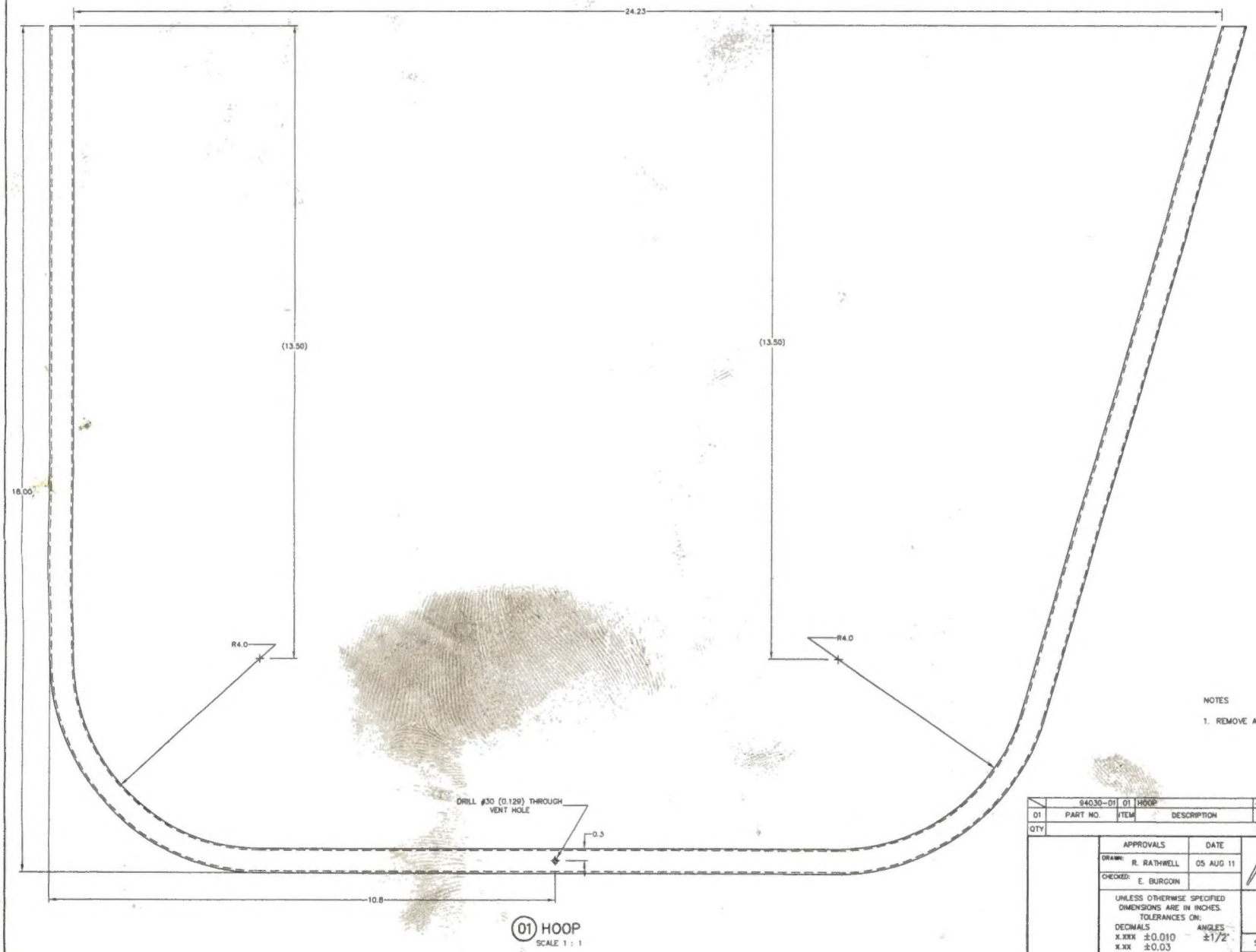
10. Clean up A006
    a. Grind high spots off mesh welds.
    b. Tighten mesh using special pliers. Tighten enough to remove "oil canning", where mesh springs in or out. Do not tighten in corners of hoops, mesh will be deformed.
    c. Drill #9 through lid prop bushing(s). De-burr hole(s).
    d. Remove surface rust with scotch-brite pad.

11. Final Inspection
    To be completed by a different person than the previous steps.
    a. Basket body assembly for complete welds, and required minimum mesh weld locations.
    b. Filled vent holes – usually on hoops
    c. Overall condition and conformity to drawing(s).
        i. Hoops for height.
        ii. Rim for width and length and alignment.
        iii. Lid prop lugs in correct ends.
        iv. Fore/aft strut in hoop if required by drawing.
    d. Material lists complete.

e. Tag complete basket body assembly in preparation for powder coating.

12. Powder Coating
    a. Parts are to be powder coated white in accordance with commercial practices.
    b. Record powder coating PO.
    c. Inspect powder coating on receiving.
    d. Tag basket body assembly and place into stock in preparation for assembly.

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	TITLE BLOCK UPDATED; DRAWING REFORMATTED TO A1	BJC	11/07/2014



(01) HOOP
SCALE 1 : 1

NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.

QTY	01 PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
	94030-01	01	HOOP	4130 STEEL COND. N	MIL-T-6736	0.5 X 0.035 SQR TUBE

LIST OF MATERIALS

APPROVALS	DATE
DRAWN: R. RATHWELL	05 AUG 11
CHECKED: E. BURGOIN	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:

DECIMALS	ANGLES
X.XXX ±0.010	±1/2°
X.XX ±0.03	
X.X ±0.1	

AERO DESIGN LTD.
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POWELL RIVER, BC, CANADA, V8A 0G3
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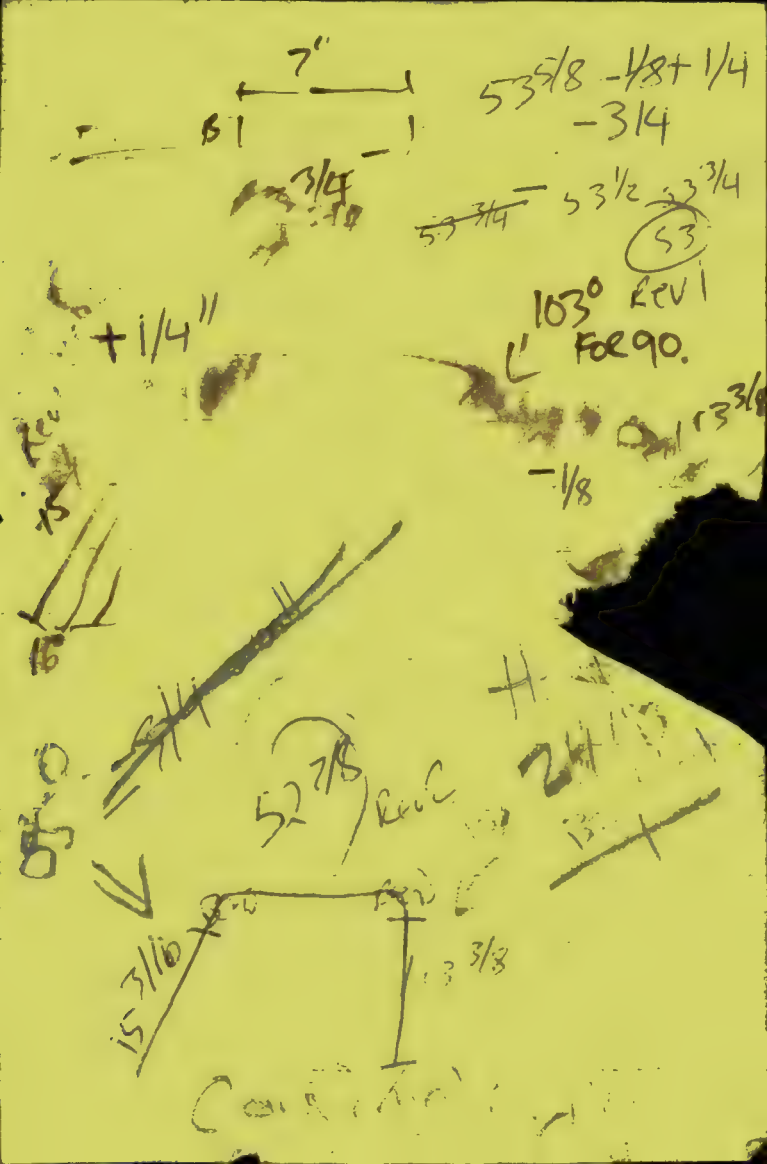
EUROCOPTER AS350 & AS355 SERIES
QUICK RELEASE CARGO BASKET
HOOP

SCALE	DWG SIZE	DWG NO.	REV.
1 : 1	A1	94030	1
SHEET 1 OF 1			


7"
53 5/8 - 1/8 + 1/4
- 3/4
53 1/2
53 3/4
53
103° REV
FOR 90.
+ 1/4"
- 1/8
52 7/8
15 3/16
13 3/8

Aero Design Ltd.
9888 A Malaspina Rd. Powell River, BC, V8A 0G3
Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

(50)

Nomenclature: CAP (HOOP TRANSITION) (0.032 1018 STEEL)
Manufacturuer: AERO DESIGN
Part No.: 7643-04 Serial / Batch No.: PO 9010 / 1731 (laser)
TTSN: N/A TSO: N/A Rem.: N/A
Work Order No.: TBA
Remaining Tasks to be Performed: WELD TO HOOP ASSY
QTY 117

Signature:
Date: 25 JULY 2013 Lic. No. / ACA

In Process

Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

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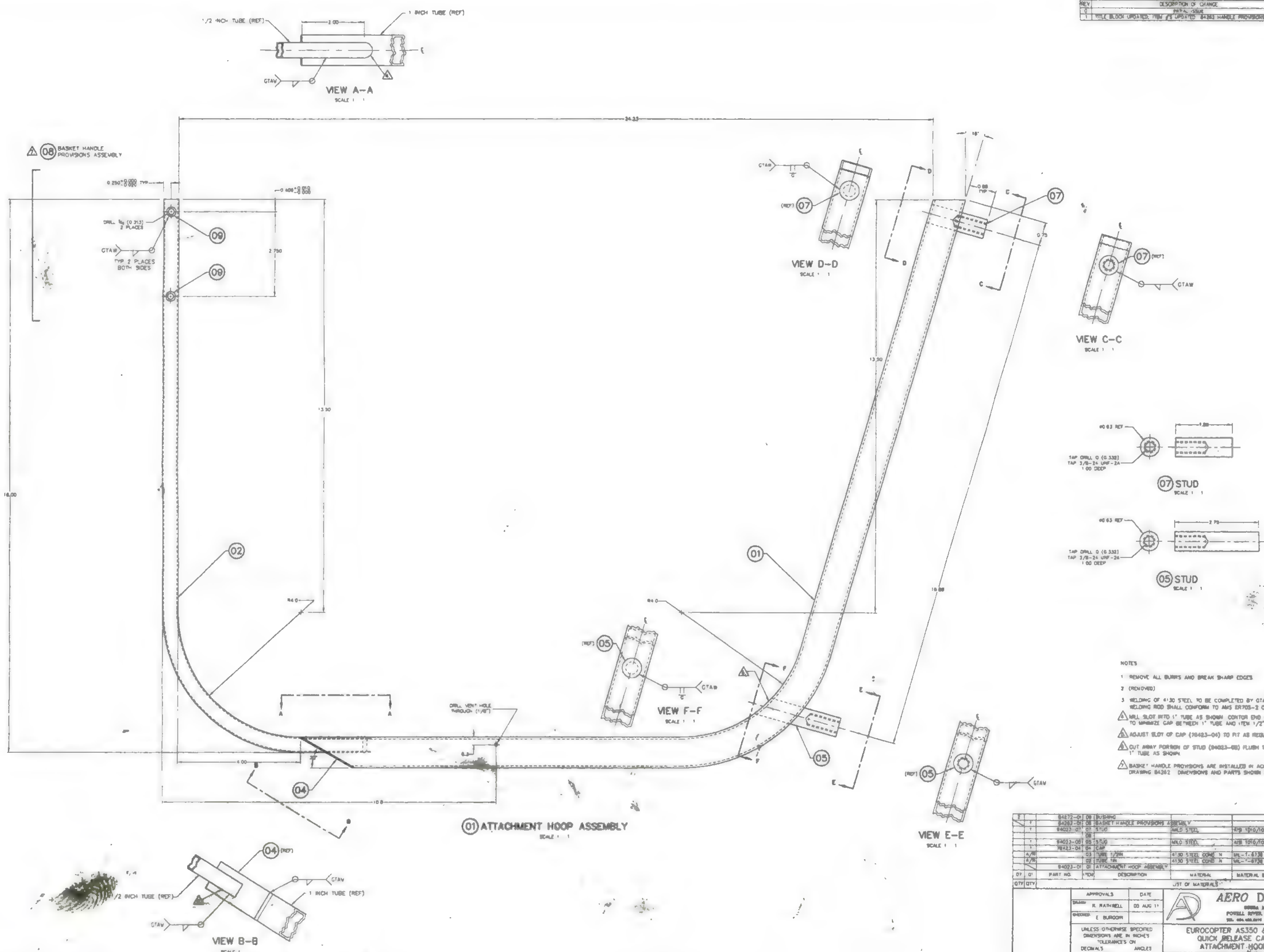
AMF 73-04

Remarks

In Process

REV	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	TITLE BLOCK UPDATED, ITEM #3 UPDATED. 84262 HANDLE PROVISIONS ADDED	BJC	11/07/2014



NOTES

1 REMOVE ALL BURRS AND BREAK SHARP EDGES.
2 (REMOVED)
3 WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS2685C. WELDING ROD SHALL CONFORM TO AMS ER70S-2 OR EQUIVALENT.
4 MILL SLOT INTO 1" TUBE AS SHOWN. CONTOUR END OF 1/2" TUBE TO MINIMIZE GAP BETWEEN 1" TUBE AND ITEM 1/2" TUBE.
5 ADJUST SLOT OF CAP (78423–04) TO FIT AS REQUIRED.
6 CUT AWAY PORTION OF STUD (94023–05) FLUSH TO INSIDE SURFACE OF 1" TUBE AS SHOWN.
7 BASKET HANDLE PROVISIONS ARE INSTALLED IN ACCORDANCE WITH AERO DESIGN DRAWING 84262. DIMENSIONS AND PARTS SHOWN ARE FOR REFERENCE ONLY.

07 QTY	01 QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
2		84272–01	09	BUSHING			
	1	84262–01	08	BASKET HANDLE PROVISIONS ASSEMBLY			
	1	94023–07	07	STUD	MILD STEEL	AISI 1010/1020	Ø0.63 ROD
			06				
	1	94023–05	05	STUD	MILD STEEL	AISI 1010/1020	Ø0.63 ROD
	1	78423–04	04	CAP			
	A/R		03	TUBE 1/2IN	4130 STEEL COND N	MIL–T–6736	0.5 x 0.035 SQR TUBE
	A/R		02	TUBE 1IN	4130 STEEL COND N	MIL–T–6736	1 x 0.065 SQR TUBE
		94023–01	01	ATTACHMENT HOOP ASSEMBLY			

LIST OF MATERIALS

APPROVALS	DATE
DRAWN R. RATHWELL	03 AUG 11
CHECKED E. BURGOIN	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:
DECIMALS: X.XXX ±0.010; X.XX ±0.03; X.X ±0.1
ANGLES: ±1/2°

AERO DESIGN LTD.
POWELL RIVER, BC CANADA

EUROCOPTER AS350 & AS355 SERIES
QUICK RELEASE CARGO BASKET
ATTACHMENT HOOP ASSEMBLY

SCALE 1 : 1	SIZE	DWG. NO.	REV
SHEET 1 OF 1	A0	94023	1

AS350 SKI

1" Hoop Bend

Requirements
*Review LOED to ensure most up to date specifications.
* Cut 33 3/8.
*Cut one end at 16 degrees and the other at 60 degrees.
* At the 16 degree end measure up 21 1/8 and mark.
* Line up the mark on the radius of the bender and bend.
~~Lower stop to 101 degree~~

~~STOP 103~~ MK

~~STOP 101 Rev 2~~ MK.

102 Rev 3

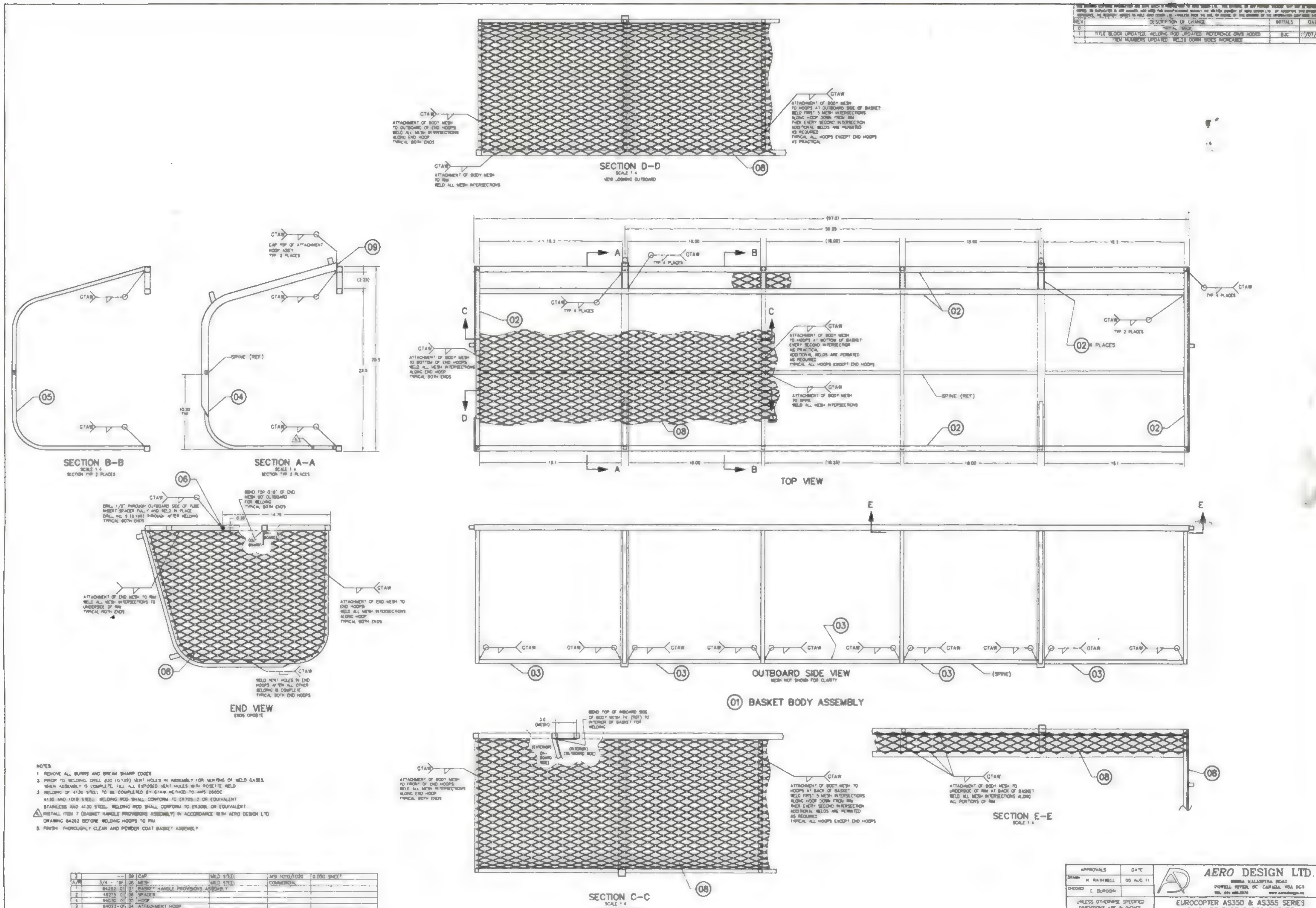
6

6 .12 - 6

7 per

30

16. 14.



NOTES:

1. REMOVE ALL BURRS AND BREAK SHARP EDGES
2. PRIOR TO WELDING, DRILL Ø30 (0.128) VENT HOLES IN ASSEMBLY FOR VENTING OF WELD GASES. WHEN ASSEMBLY IS COMPLETE, FILL ALL EXPOSED VENT HOLES WITH ROSETTE WELD
3. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2685C
   4130 AND 1010 STEEL: WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT
   STAINLESS AND 4130 STEEL: WELDING ROD SHALL CONFORM TO ER308L OR EQUIVALENT
4. (△) INSTALL ITEM 7 (BASKET HANDLE PROVISIONS ASSEMBLY) IN ACCORDANCE WITH AERO DESIGN LTD DRAWING 84262 BEFORE WELDING HOOPS TO RIM.
5. FINISH: THOROUGHLY CLEAN AND POWDER COAT BASKET ASSEMBLY

QTY	PART NO	ITEM	DESCRIPTION	MATERIAL/NOTE	MATERIAL SPEC	STOCK SIZE
2	--	09	CAP	MILD STEEL	AISI 1010/1020	0.050 SHEET
A/R	3/4 - 16F	08	MESH	MILD STEEL	COMMERCIAL	
1	84262-01	07	BASKET HANDLE PROVISIONS ASSEMBLY			
2	49215-01	06	SPACER			
4	94030-01	05	HOOP			
2	94023-01	04	ATTACHMENT HOOP			
A/R	-	03	SQUARE TUBE	4130 STEEL COND N	MIL-T-6736	1/2 X 0.035 SQR TUBE
A/R	-	02	SQUARE TUBE	4130 STEEL COND N	MIL-T-6736	3/4 X 0.035 SQR TUBE
	94011-01	01	BASKET BODY ASSEMBLY			

LIST OF MATERIALS

REV	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	TITLE BLOCK UPDATED, WELDING ROD UPDATED, REFERENCE DIMS ADDED ITEM NUMBERS UPDATED, WELDS DOWN SIDES INDICATED	BJC	17/07/2014

APPROVALS	DATE
DRAWN R. RATHWELL	05 AUG 11
CHECKED E. BURGOIN	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES ON
DECIMALS: X.XXX ±0.010; X.XX ±0.03; X.X ±0.1
ANGLES: ±1/2°

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EUROCOPTER AS350 & AS355 SERIES
QUICK RELEASE CARGO BASKET
BASKET BODY ASSEMBLY (EXTRA LARGE)

SCALE 1:4 | SHEET 1 OF 1 | DWG SIZE A0 | DWG NO. 94011 | REV 1

Work Order: 20S-74

Date Opened: 24-Jun-15

Material Tracking Sheet
Eurocopter AS350 / AS355
Extra Large Basket Body Fabrication

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	3	94011	**94011-01**	**Basket Assembly**		
Step 1				*Rim Assembly*		
	. 2		--	3/4" Tube - Long Rim (97")	4130 Steel, ¾" x 0.035 Sqr. Tube	14099
	. 2		--	3/4" Tube - Short Rim (25.5")	4130 Steel, ¾" x 0.035 Sqr. Tube	14099
	. 1		--	3/4" Tube - Long Stringer (95.5")	4130 Steel, ¾" x 0.035 Sqr. Tube	14099
	. 4		--	3/4" Tube - Short Stringer (2.25")	4130 Steel, ¾" x 0.035 Sqr. Tube	12111
Step 2				*Weld Rim Assembly*		
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	14033
Step 3				*Inspection - Rim*	*None*	
Step 4				*Frame Assembly*		
	. 4		94030-01	Hoop - standard	4130 Steel, ½" x 0.035 Sqr. Tube	14099
	. 2		94023-01	Hoop - attachment		Attached
	. 5		--	1/2" Tube - spine	4130 Steel, ½" x 0.035 Sqr. Tube	14099
Step 4.g.		70406	70406-01	*Option: Front End Cutout*		
			70406-03	1/2" Tube	4130 Steel, ½" x 0.035 Sqr. Tube	N/A
			70406-04	1/2" Tube	4130 Steel, ½" x 0.035 Sqr. Tube	
Step 5				*Weld Frame Assembly*		
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	14033
Step 6				*Inspection - Frame Assembly*	*None*	
Step 7				*Mesh Assembly*		
	. 1		--	Mesh (Body - 56" x 96")	3/4-16F Expanded Mild Steel sheet	~~12065~~ re 12130
	. 2		--	Mesh (End - 25" x 18")	3/4-16F Expanded Mild Steel sheet	12065

Work Order: 2015-74

Date Opened: 24 JUNE 2015

Material Tracking Sheet
Eurocopter AS350 / AS355
Extra Large Basket Body Fabrication

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 8				*Weld Mesh*		
	. A/R		--	Welding Rod	ER70S-6 MIG Wire	~~14028~~ 14033
Step 9				*Weld Basket Components*		
	. 2		49215-01	Spacer (Lid prop)	304 Stainless Steel, ½" Dia.	14092
	. A/R		--	Welding Rod	ER308L TIG Rod	~~14033~~ 14028
Step 10				*Clean Up*	*None*	
Step 11				*Inspection - Final Assembly*	*None*	
Step 12				Powder Coating		15047

Work Order: 205-74

Date Opened: 24-Jun-15

Material Tracking Sheet
Eurocopter AS350 / AS355
Extra Large Hoops Fabrication

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	36		**94030-01**	**Hoop - standard**	4130 Steel, ½" x 0.035 Sqr. Tube	14099
	12		**94023-01**	**Hoop - attachment**		
Step 1				*1/2 Hoop Fabrication - 1/2" hoop*		~~14099~~ ma
	. 1		--	1/2" Tube - hoop	4130 Steel, ½" x 0.035 Sqr. Tube	14099
Step 2				*Machining*	*None*	
Step 3				*1/2 Hoop Fabrication - 1" hoop*		
	. 1		--	1" tube - hoop	4130 Steel, 1" x 0.065 Sqr. Tube	15015
Step 4				*Machining*	*None*	
Step 5				*Joint Preparation*	*None*	
				Welding		
Step 6	. 1		94023-05	Stud	1018 Mild Steel, 5/8" Dia.	2015-65
	. 1		94023-07	Stud	1018 Mild Steel, 5/8" Dia.	2015-66
Step 7	. 2	84262	84272-01	Bushing	4130 Steel, 5/16" x 0.058 Rnd. Tube	15024
Step 8	. 1		76423-04	Cap	1018 Mild Steel, 0.050" Sheet	9010/1213
	. A/R		--	Welding Rod	ER70S-2 14037	
Step 9				*Finishing and Inspection*	*None*	

Aero Design

Parts Distribution Sheet

Description: ____________________ WO# 2015-74

From PO or WO #	Quantity	Description	Part Number	For WO #
SEE		MATERIAL	TRACKING	
		SHEETS		